

# Work Order ID 56192

February 12, 2010 10:38:03 AM



Page 1

Item ID: D3836-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 10-2-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-1 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

*SAD 10-02-24*

4- weld D3836-1 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: *m109213*

6- grind weld flush where indicated on dwg

*(2)*

*PL 10-03-01*

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*(2)*

*PD 10-03-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 56192**

February 12, 2010 10:38:03 AM



Page 2

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Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S10/03/01

(2)

-040

Quality Control

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

SAP 10-03-01

(2)

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/03/03

Quality Control

MF  
10-3-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 12, 2010 10:38:08 AM

Page 1

Work Order ID: 56192



Parent Item: D3836-041



Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3		Manufactured	No			100	Each	51.0000	2.0000			
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Spacer Bushing

*Handwritten signature*  
10-03-01

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

ST	13	
----	----	--

44274	4	
-------	---	--

44365	9	
-------	---	--

Main Warehouse

WA	38	
----	----	--

55167	18	
-------	----	--

55917	20	
-------	----	--

*Handwritten asterisk and signature*

M304TS0.750W.065	Purchased	No				100	f	473.1552	3.7491			
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304 SQ Tube .75x.75x.065W



SAD 10-02-24

Warehouse Location	Loc Qty	Loc Code
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Main Warehouse

MAT	473.1552242	
-----	-------------	--

113082	0.00419	
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113245	0.00038421	
--------	------------	--

113683	16.30855	
--------	----------	--

113836	76.8421	
--------	---------	--

113956	380	
--------	-----	--

Main Warehouse

WA	0.0000047	
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112398	0.0000047	
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*Handwritten signature and number*  
3.7491

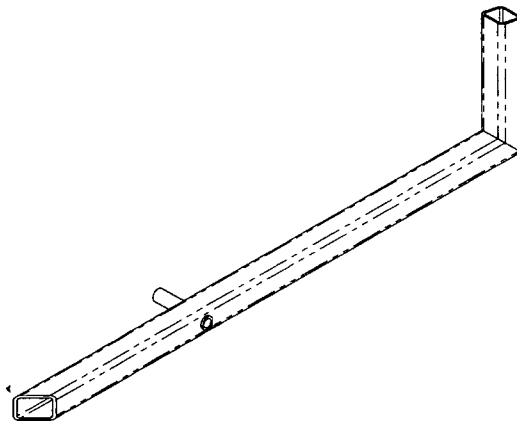
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

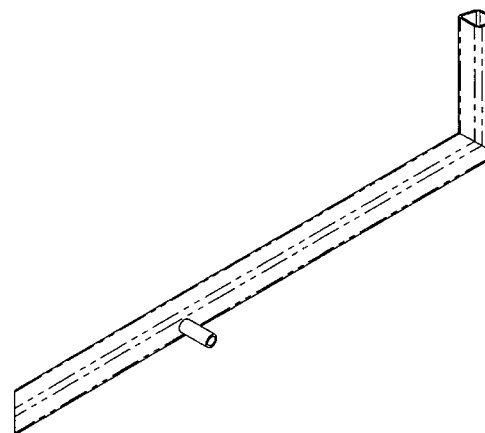
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D3836-042 RIB ASSY (BASKET LID, RH)**



**D3836-041 RIB ASSY (BASKET LID, LH)**

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36192

*BS 10-2-12*

**RELEASED**  
*CM/RA MP*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.99 lbs EACH
- 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3836** REV. A  
SHEET 1 OF 3  
TITLE **RIB ASSY (BASKET LID)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

1

D3836-1  
RIB

0.94

D2327-3  
SPACER BUSHINGD3836-3  
RIB6.00  
REF**D3836-041 RIB ASSY (BASKET LID, LH)**D3836-2  
RIB

0.94

D2327-3  
SPACER BUSHINGD3836-3  
RIB6.00  
REF**D3836-042 RIB ASSY (BASKET LID, RH)**

w/o 36192

**RELEASED**  
08/11/18 JH

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8

7

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2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

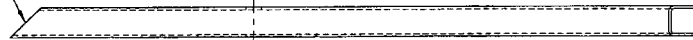
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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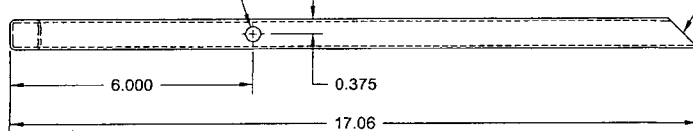
**NOTE:** Date & initial all entries

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CHAMFER

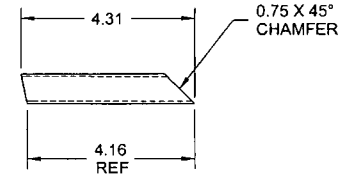


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0.75 X 45°  
CHAMFER

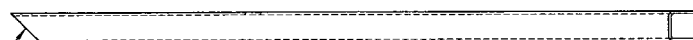


**D3836-1 RIB**



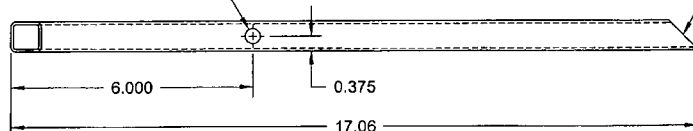
**D3836-3 RIB**

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CHAMFER

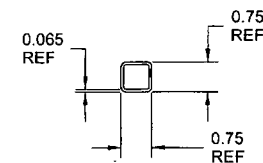


$\varnothing 0.375^{+0.020}_{-0.000}$  THRU

0.75 X 45°  
CHAMFER



**D3836-2 RIB**



**TYPICAL SECTION  
VIEW**

**RELEASED**  
08/11/18

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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